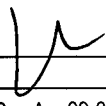


Ship Asst 13/14/04

Dart Aerospace Ltd.

Date: Thursday, 09/04/2009 10:43:26 AM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOUBLER
<b>Job Number</b> : 47102	
<b>Estimate Number</b> : 13849	
<b>P.O. Number</b> :	<b>Part Number</b> : D32945
<b>This Issue</b> : 09/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3294 REV.C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : C
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> : 	<b>Due Date</b> : 13/04/2009 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev:A 09-04-08 New issue DD verified by:	

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S080	2024-T3 .080 sheet
-----	-------------	--------------------



0.065 3 09.04.15



**Comment:** Qty.: ~~1.0177~~ sf(s)/Unit Total : 19.1772 sf(s)  
Material: 2024-T3 (QQ-A-250/4) 0.080" thick  
(M2024T3S.080)  
Identify for D3293-1  
Batch: 110908 IR 9-4-13

(12)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
1-Cut as per Dwg D3294  
Dwg Rev: C  
Prog Rev: C

1B 9-4-13

\*\*\*\*grain direction as per dwg D3294 \*\*\*\*

2-Deburr if necessary 1B 9-4-13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



1B 9-4-13



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

S 09/04/13 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 09/04/2009 10:43:26 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 47102

Part Number: D32945

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



PTO

Comment: NC BRAKE

1- Deburr if necessary

2- Bend as per Dwg D3294

SB 09/04/13 (11)

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/13 (11)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 09-04-14 (11)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/14 (11)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G A

SB 09/04/14 (11)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14 (11)

Job Completion


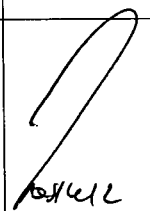
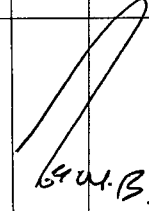


MF 09-04-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3294-5 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: EW Date: 02/04/15  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>47102</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/13	5	1 part was bent on wrong side mis-interpreted the drawing view R.C. Dimension error.		Scrap & destroy No replace	SB 09/04/13	S 02/04/13		

NOTE: Date & initial all entries

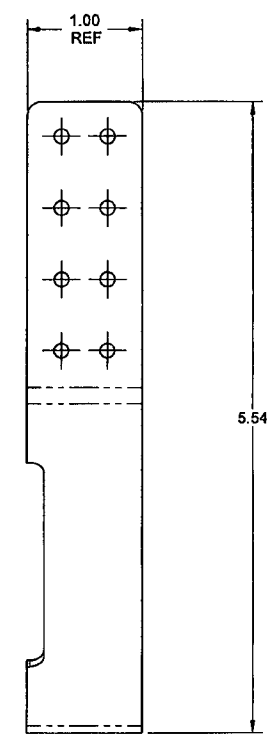
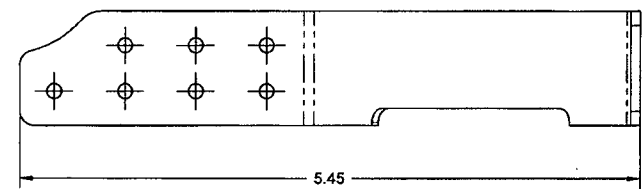
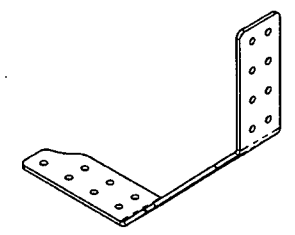


8 7 6 5 4 3 2 1

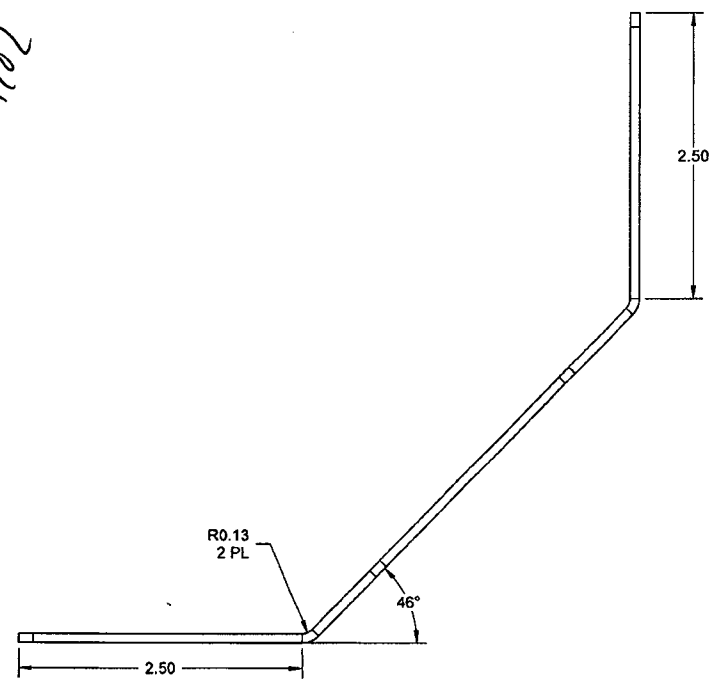
D  
C  
B  
A

D  
C  
B  
A

*WLB*  
*47102*



*47102*



**D3294-5 DOUBLER**  
MADE FROM D3294-5F

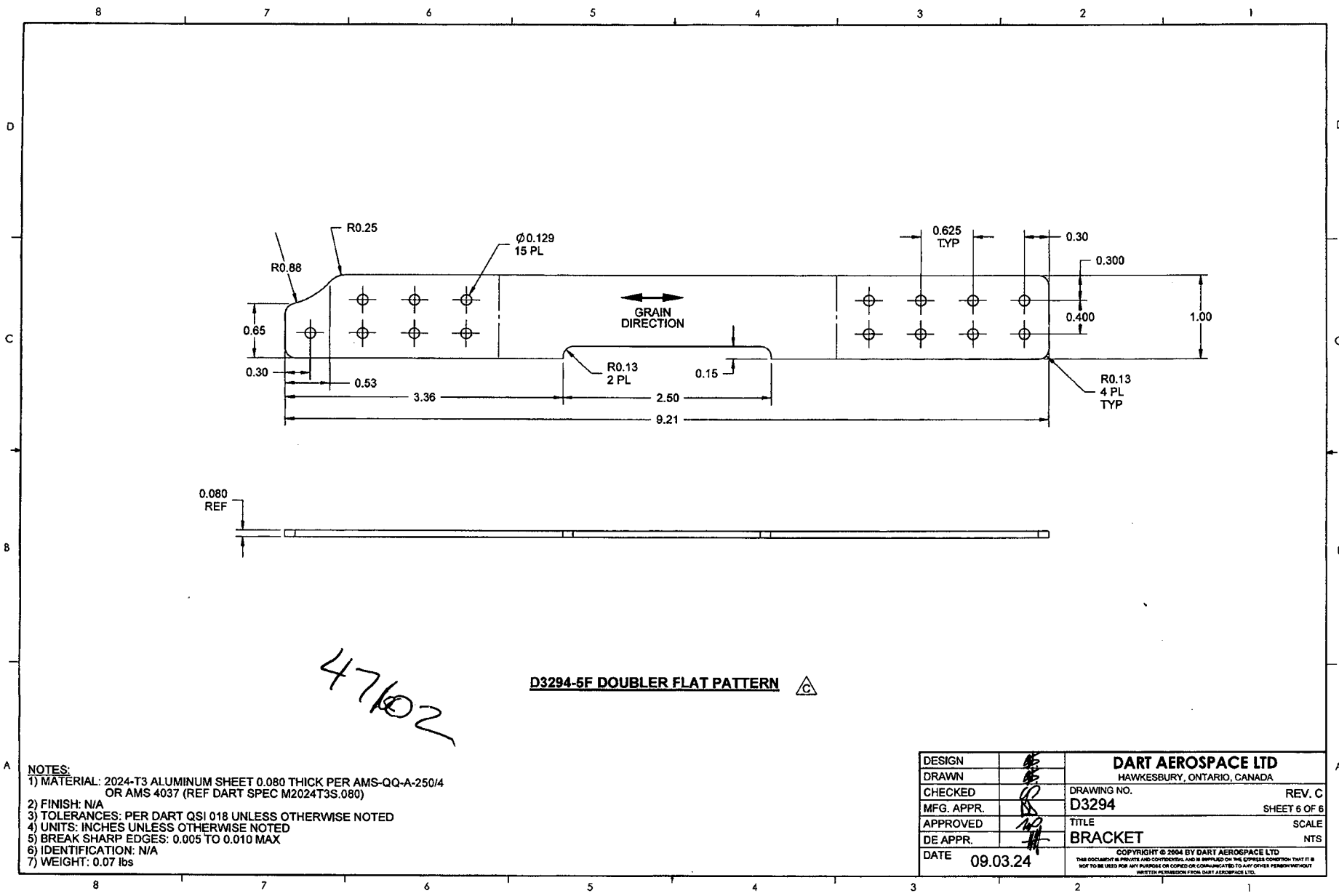


**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3294</b>	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
DATE	09.03.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



**D3294-5F DOUBLER FLAT PATTERN** ⚠

- NOTES:**  
 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.07 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3294	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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